

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000038**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 08-Jan-2007**Location:** Changxing Island, Shanghai, China
Submittals(New / Total): **CWR's: 0 / 0** **HSR's: 0 / 0** **NCR's: 0 / 0**

Item	Title	Detail
1	Critical Weld Repairs (CWRs)	N/A
2	Heat Straightening Requests (HSRs)	N/A
3	Nonconformance Reports (NCRs)	N/A
4	Major component movement	Performed Mechanical Testing for the following PQR test plates:

1G Submerged Arc Welding (SAW) procedure identified as HP-2006135
Charpy-V Notch weld metal samples failed.

1G Submerged Arc Welding (SAW) procedure identified as HP-2006134
testing appeared to comply.

1G Submerged Arc Welding (SAW) procedure identified as HP-2006130 1
side bend sample failed ? ZPMC to cut 2 new samples for re-test.

1G Flux Core Arc Welding (FCAW) procedure, HP-2006107-9 testing
appeared to comply.

3G Flux Core Arc Welding (FCAW) procedure, HP-2006122 testing
appeared to comply.

Conducted welding of the following PQR test plates:

3G Flux Core Arc Welding (FCAW) procedure identified as HP-2006129
on 75mm A709-345 (non-standard joint due to 20mm root). Welding is
complete.

3G Flux Core Arc Welding (FCAW) procedure identified as HP-2006131
on 75mm HPS 485W (non-standard joint due to 20mm root). Welding is
complete.

1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006133
on 75mm HPS 485W (non-standard joint due to 20mm root). Welding is
not complete and will continue Tuesday, 1-9-07.

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1G Flux Core Arc Welding (FCAW) / Submerged Arc Welding (SAW) procedure identified as HP-2006117 on 60mm HPS 485W (non-standard joint due to ceramic backing). Welding was conducted outside of the specified parameters on pass numbers 30 and 31. Previous amperage settings were 565 and these passes were conducted at 710 amps.

ZPMC revised their Proposed Weld Procedure (PWPS) and started welding HP-2006117-1, however after three FCAW passes they were outside of the were running both outside of the 10%, 7%, 10% limitations for conducted PQR's, but were also outside of the parameters qualified in the supporting figure 5.1 test plate, HP-2006107-9.

1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006116 on 60mm HPS 485W (non-standard joint due to ceramic backing). Welding is not complete and will continue Tuesday, 1-9-07.

1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006128 on 75mm A709-345 (non-standard joint due to 20mm root). Welding is not complete and will continue Tuesday, 1-9-07.

5	Meetings attended	N/A
6	Key conversations	QA spoke with ZPMC Testing Center Director Mr. Liu Liu, and ABF representative Craig Knops regarding the requirements for conducting non-standard joint qualifications. QA pointed out that they must be within the parameters qualified during the Figure 5.1 (mechanical properties test plate) and is further restricted by the requirements in Table 5.3, which restricts the amperage to +/- 10%, voltage to +/- 7% and travel speed to +/- 10% (+/- 15% for SAW). ZPMC technology department stated that they did not have to qualify procedure HP-2006117 at all since the individual processes were already qualified, and the code allows for PQR tested separately to be combined without further testing. QA pointed out that this is only applicable to joints listed in AWS D1.5, Figures 2.4 and 2.5. Since they are utilizing a ceramic backing, the joint is required to be qualified in accordance with AWS D1.5, Section 5.13.
7		
8	Other important observations	ABF representative Craig Knops appears to be trying to use Caltrans to direct their sub-contractor ZPMC. QA spoke with Mr. Knops regarding this and informed him that Caltrans' contract is with ABF, and that ABF should be the one directing their sub-contractor ZPMC.
9	Quality Assurance Inspectors per shift	3 AM 0 PM
10	Logistics	
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Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
